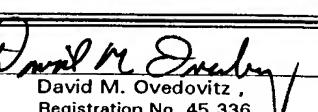


FORM PTO 1390 (REV 5-93) US DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE  TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. §371		ATTORNEY DOCKET NUMBER 2002_0214A
		U.S. APPLICATION NO. (If known, enter here) NEW <b>10/069585</b>
International Application No. PCT/JP00/05733	International Filing Date August 25, 2000	Priority Date Claimed August 27, 1999
<p><b>Title of Invention</b> PERMANENT MAGNET FIELD SMALL DC MOTOR</p> <p><b>Applicant(s) For DO/EO/US</b> MATSUSHITA ELECTRIC INDUSTRIAL CO., LTD. et al</p> <p>Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:</p> <ol style="list-style-type: none"> <li><input checked="" type="checkbox"/> This is a <b>FIRST</b> submission of items concerning a filing under 35 U.S.C. §371.</li> <li><input type="checkbox"/> This is a <b>SECOND</b> or <b>SUBSEQUENT</b> submission of items concerning a filing under 35 U.S.C. §371.</li> <li><input checked="" type="checkbox"/> This express request to begin national examination procedures (35 U.S.C. §371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. §371(b) and PCT Articles 22 and 39(1).</li> <li><input checked="" type="checkbox"/> A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date.</li> <li><input checked="" type="checkbox"/> A copy of the International Application as filed (35 U.S.C. §371(c)(2)) <ul style="list-style-type: none"> <li>a. <input type="checkbox"/> is transmitted herewith (required only if not transmitted by the International Bureau).</li> <li>b. <input checked="" type="checkbox"/> has been transmitted by the International Bureau. ATTACHMENT A</li> <li>c. <input type="checkbox"/> is not required, as the application was filed in the United States Receiving Office (RO/US)</li> </ul> </li> <li><input checked="" type="checkbox"/> A translation of the International Application into English (35 U.S.C. §371(c)(2)). ATTACHMENT B</li> <li><input type="checkbox"/> Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. §371(c)(3)). <ul style="list-style-type: none"> <li>a. <input type="checkbox"/> are transmitted herewith (required only if not transmitted by the International Bureau).</li> <li>b. <input type="checkbox"/> have been transmitted by the International Bureau.</li> <li>c. <input type="checkbox"/> have not been made; however, the time limit for making such amendments has NOT expired.</li> <li>d. <input type="checkbox"/> have not been made and will not be made.</li> </ul> </li> <li><input type="checkbox"/> A translation of the amendments to the claims under PCT Article 19.</li> <li><input type="checkbox"/> An oath or declaration of the inventor(s) (35 U.S.C. §371(c)(4)).</li> <li><input checked="" type="checkbox"/> A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. §371(c)(5)). ATTACHMENT C Kindly enter the amended claims (Article 34 Amendment) of attachment C prior to calculation of the filing fee.</li> </ol> <p><b>Items 11. to 14. below concern other document(s) or information included:</b></p> <ol style="list-style-type: none"> <li><input checked="" type="checkbox"/> An Information Disclosure Statement under 37 CFR 1.97 and 1.98. ATTACHMENT D</li> <li><input type="checkbox"/> An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.</li> <li><input checked="" type="checkbox"/> A <b>FIRST</b> preliminary amendment. ATTACHMENT E <ul style="list-style-type: none"> <li><input type="checkbox"/> A <b>SECOND</b> or <b>SUBSEQUENT</b> preliminary amendment.</li> </ul> </li> <li><input checked="" type="checkbox"/> Other items or information: <ul style="list-style-type: none"> <li>Notification Concerning Submission Or Transmittal Of Priority Document ATTACHMENT F</li> <li>Written Opinion ATTACHMENT G</li> <li>International Preliminary Examination Report (in Japanese) ATTACHMENT H</li> <li>Unexecuted Declaration and Cover Letter ATTACHMENT I</li> </ul> </li> </ol> <p style="text-align: right;">THE COMMISSIONER IS AUTHORIZED TO CHARGE ANY DEFICIENCY IN THE FEES FOR THIS PAPER TO DEPOSIT ATTACHMENT NO. 23-0975</p>		

U.S. APPLICATION NO. <b>10/069585</b>	INTERNATIONAL APPLICATION NO. PCT/JP00/05733	ATTORNEY'S DOCKET NO. 2002_0214A																	
		<b>CALCULATIONS</b>	<b>PTO USE ONLY</b>																
<p>15. <input checked="" type="checkbox"/> The following fees are submitted</p> <p><b>BASIC NATIONAL FEE (37 CFR 1.492(a)(1)-(5)):</b></p> <p>Neither international preliminary examination fee nor international search fee paid to USPTO and International Search Report not prepared by the EPO or JPO ..... \$1040.00</p> <p>International Search Report has been prepared by the EPO or JPO ..... \$ 890.00</p> <p>International preliminary examination fee not paid to USPTO but international search paid to USPTO ..... \$ 740.00</p> <p>International preliminary examination fee paid to USPTO but claims did not satisfy provisions of PCT Article 33(1)-(4) ..... \$ 690.00</p> <p>International preliminary examination fee paid to USPTO and all claims satisfied provisions of PCT Article 33(1)-(4) ..... \$ 100.00</p> <p><b>ENTER APPROPRIATE BASIC FEE AMOUNT =</b></p> <p style="text-align: right;">\$890.00</p> <p>Surcharge of \$130.00 for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input checked="" type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(e)).</p> <p style="text-align: right;">\$</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;">Claims</td> <td style="width: 25%;">Number Filed</td> <td style="width: 25%;">Number Extra</td> <td style="width: 25%;">Rate</td> </tr> <tr> <td>Total Claims</td> <td>9 -20 =</td> <td>0</td> <td>X \$18.00</td> </tr> <tr> <td>Independent Claims</td> <td>2 - 3 =</td> <td>0</td> <td>X \$84.00</td> </tr> <tr> <td colspan="2">Multiple dependent claim(s) (if applicable)</td> <td></td> <td>+ \$280.00</td> </tr> </table> <p><b>TOTAL OF ABOVE CALCULATIONS =</b></p> <p style="text-align: right;">\$890.00</p> <p><input type="checkbox"/> Small Entity Status is hereby asserted. Above fees are reduced by 1/2.</p> <p style="text-align: right;">\$</p> <p><b>SUBTOTAL =</b></p> <p style="text-align: right;">\$890.00</p> <p>Processing fee of \$130.00 for furnishing the English translation later than <input type="checkbox"/> 20 <input checked="" type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(f)).</p> <p style="text-align: right;">+ \$</p> <p><b>TOTAL NATIONAL FEE =</b></p> <p style="text-align: right;">\$890.00</p> <p>Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31). \$40 per property +</p> <p style="text-align: right;">\$</p> <p><b>TOTAL FEES ENCLOSED =</b></p> <p style="text-align: right;">\$890.00</p> <p style="text-align: right;">Amount to be refunded \$</p> <p style="text-align: right;">Amount to be charged \$</p> <p>a. <input checked="" type="checkbox"/> A check in the amount of <u>\$890.00</u> to cover the above fees is enclosed. A duplicate copy of this form is enclosed.</p> <p>b. <input type="checkbox"/> Please charge my Deposit Account No. 23-0975 in the amount of \$ _____ to cover the above fees. A duplicate copy of this sheet is enclosed.</p> <p>c. <input checked="" type="checkbox"/> The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. <u>23-0975</u>.</p> <p><b>NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.</b></p> <p>19. CORRESPONDENCE ADDRESS</p> <p style="text-align: center;"> <b>000513</b></p> <p>PATENT TRADEMARK OFFICE</p> <p>By:  David M. Ovedovitz, Registration No. 45,336</p> <p>WENDEROTH, LIND &amp; PONACK, L.L.P. 2033 "K" Street, N.W., Suite 800 Washington, D.C. 20006-1021 Phone: (202) 721-8200 Fax: (202) 721-8250</p> <p style="text-align: right;">February 27, 2002</p>				Claims	Number Filed	Number Extra	Rate	Total Claims	9 -20 =	0	X \$18.00	Independent Claims	2 - 3 =	0	X \$84.00	Multiple dependent claim(s) (if applicable)			+ \$280.00
Claims	Number Filed	Number Extra	Rate																
Total Claims	9 -20 =	0	X \$18.00																
Independent Claims	2 - 3 =	0	X \$84.00																
Multiple dependent claim(s) (if applicable)			+ \$280.00																

**19. CORRESPONDENCE ADDRESS**



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84

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February 27, 2002

[CHECK NO.]

[2002\_0214A]

#4/1a

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re application of

Fumitoshi YAMASHITA et al. : Attn: **BOX PCT**

Serial No. NEW : Docket No. **2002\_0214A**

Filed February 27, 2002 :

PERMANENT MAGNET FIELD SMALL DC MOTOR

[Corresponding to PCT/JP00/05733

Filed August 25, 2000]

**PRELIMINARY AMENDMENT**

Assistant Commissioner for Patents,  
Washington, DC 20231

THE COMMISSIONER IS AUTHORIZED  
TO CHARGE ANY DEFICIENCY IN THE  
FEES FOR THIS PAPER TO DEPOSIT  
ACCOUNT NO. 23-0975

Sir:

Please amend the above-identified U.S. Patent application as follows:

**IN THE SPECIFICATION**

**Please amend the specification as follows.**

**Please replace the paragraph beginning on page 3, line 5 with the following new paragraph.**

Among the motors having an arc-shaped magnet, regardless whether it is a rare earth magnet or not, known technologies for reducing the cogging torque through a shape of the arc-shaped magnet include making a radius of the outer surface of the arc-shaped magnet to be different from that of the inner surface, or cutting edges at both ends in the circumferential direction of an arc-shaped magnet, thereby making a distribution of flux density in the air-gap closer to a sine curve (an example of the publication: Shogo Tanaka, "Application of Permanent Magnets for Small Motors", page 7 in the proceedings of the Symposium of Small Motor Technology, 1983). Japanese Utility Model Publication No. S49-4651 discloses that, in a permanent magnet field small DC motor, a cut provided in an arc-shaped magnet in the outer surface at both sides off of the center of the magnetic pole suppresses reduction of effective flux at the center of magnetic pole, despite the reduction at the

cut portion. Although there is no mention about the cogging torque in the Utility Model, there is an indication about a possibility that the cut provided in an arc-shaped magnet in the outer surface at both sides off of the center of the magnetic pole would reduce the cogging torque in a permanent magnet field small DC motor, while controlling deterioration of the rotating torque.

**IN THE CLAIMS**

**Please amend claims 9 as follows.**

9. (Amended) An optical pickup device comprising: a permanent magnet field small DC motor comprising an arc-shaped permanent magnet fixed in a soft-magnetic frame, wherein said magnet is provided with an outer surface at both ends in a thrust direction that fits along an inner surface of said soft-magnetic frame, and a certain region in a middle part in the thrust direction of said magnet at both ends in the circumferential direction where said soft-magnetic frame does not function as a back yoke.

**REMARKS**

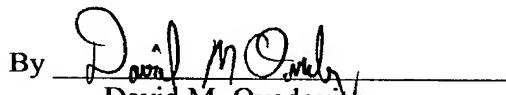
In view of the above amendments and the following remarks, reconsideration and further examination are requested.

The specification has been reviewed and revised to correct a typographical error. Further claim 9 has been amended to place it in better U.S. form. No new matter has been added. Enclosed is a marked-up copy of the section of the original specification and claim 9 labeled "Version with Markings to Show Changes Made" indicating the changes.

Therefore, prosecution on the merits is now respectfully requested.

Respectfully submitted,

Fumitoshi YAMASHITA et al.

By   
\_\_\_\_\_  
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February 27, 2002

Version with Markings to  
Show Changes Made

Among the motors having an arc-shaped magnet, regardless whether it is a rare earth magnet or not, known technologies for reducing the cogging torque through a shape of the arc-shaped magnet include making a radius of the outer surface of the arc-shaped magnet to be different from that of the inner surface, or cutting edges at both ends in the circumferential direction of an arc-shaped magnet, thereby making a distribution of flux density in the air-gap closer to a sine curve (an example of the publication: Shogo Tanaka, "Application of Permanent Magnets for Small Motors", page 7 in the proceedings of the Symposium of Small Motor Technology, 1983). Japanese Utility Model Publication No. [S44-4651] S49-4651 discloses that, in a permanent magnet field small DC motor, a cut provided in an arc-shaped magnet in the outer surface at both sides off of the center of the magnetic pole suppresses reduction of effective flux at the center of magnetic pole, despite the reduction at the cut portion. Although there is no mention about the cogging torque in the Utility Model, there is an indication about a possibility that the cut provided in an arc-shaped magnet in the outer surface at both sides off of the center of the magnetic pole would reduce the cogging torque in a permanent magnet field small DC motor, while controlling deterioration of the rotating torque.

9. (Amended) An optical pickup device comprising: [the permanent magnetic field small DC motor of claim 1] a permanent magnet field small DC motor comprising[.] an arc-shaped permanent magnet fixed in a soft-magnetic frame, wherein said magnet is provided with an outer surface at both ends in a thrust direction that fits along an inner surface of said soft-magnetic frame, and a certain region in a middle part in the thrust direction of said magnet at both ends in the circumferential direction where said soft-magnetic frame does not function as a back yoke.

**PERMANENT MAGNET FIELD SMALL DC MOTOR****TECHNICAL FIELD**

5 The present invention relates to a permanent magnet field small DC motor having a thin arc-shaped rare-earth magnet of a maximum thickness of 1 mm or less, which motor operating on a low starting voltage and a low starting current yet yielding a high output with an accurate revolving performance at a lower cogging torque. A typical field of application of these motors is in an optical pickup for a MD, CD-ROM and the like audio-visual equipment.

10

**BACKGROUND ART**

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FIG. 1(a) is a cross sectional view at a key portion of a permanent magnet field small DC motor relating to the present invention; FIG. 1(b) shows an arc-shaped magnet used in the motor. In the drawings, a pair of arc-shaped magnets 1, a soft-magnetic frame 2, an armature 3, which includes a brush-rectifier, a rotating shaft and a bearing, and a U-shaped spring 4 for pressing and securing the pair of arc-shaped magnets 1 in the soft-magnetic frame 2 are shown. The permanent magnet field small DC motor under discussion is requested to be further miniaturized, yet to provide a higher output and an accurate revolving performance, like in other permanent magnet motors.

20

As a general rule among the permanent magnet field small DC motors, it is difficult to maintain the output with a diameter of the armature 3 reduced. Especially, in a motor using a ferrite magnet, whose maximum energy product [BH] max is low irrespective of whether it is fabricated by sintering, or by compression molding, injection molding or extrusion molding of a material mixed with a resin binder, the air-gap between the arc-shaped magnet 1 and an armature 3 is not provided with sufficiently strong static magnetic field when miniaturized. Hence, the output is significantly reduced. In a wish to provide the air-gap between the arc-shaped magnet 1 and the armature 3 with strong static magnetic

fields among the miniaturized motors, a rare-earth magnet in an arc-shape whose maximum thickness is 1 mm or less, which exhibiting a so-called high [BH] max value, has been required.

Regarding the arc-shaped rare-earth magnet whose maximum thickness is 1 mm or less, Japanese Patent Laid-open Publication No. H6-236807 discloses a method for fabricating an arc-shaped rare-earth magnet. The method comprising the steps of pouring a melted mixture of thermo-plastic resin-binder and various kinds of rare-earth iron based magnetic powders, ranging from anisotropic to isotropic, into a mold, and extrusion molding while cooling it below a melting point of the thermo-plastic resin-binder. According to the disclosure, an arc-shaped rare-earth magnet of 0.9 mm thick can be produced at a thickness variation  $\pm 30 \mu\text{m}$  through extrusion molding from a bonded-magnet compound of, for example, isotropic rare-earth iron based melt-spun flakes 95 weight% and a thermo-plastic resin consisting mainly of 12-nylon. However, it is also mentioned that there is a difficulty in conducting a compression molding of rare-earth-based melt-spun flakes together with a resin-binder. In the extrusion molding, the thermo-plastic resin in the melted state has to perform a role of a carrier for the rare-earth iron based melt-spun flakes. So, as compared to a compression molded rare earth magnet, which is prepared from rare-earth iron based melt-spun flakes mixed with a thermosetting resin of normally 3 weight% or less, the content of rare-earth iron based melt-spun flakes needs to be lowered in the magnet of the above disclosure. Accordingly, the [BH] max value of the magnet becomes lower, and the static magnetic fields between the arc-shaped magnet 1 and the armature 3 becomes weaker.

One of the problems with the permanent magnet field small DC motor comprising the arc-shaped rare earth magnet fabricated through the above extrusion molding, which provides a stronger static magnet field in an air-gap to the armature 3 as compared to a ferrite magnet motor, is an increased cogging torque. This is the torque pulsation due to permeance changes as a result of revolution of the armature 3 caused by iron core teeth 31 and a slot 32 existing on the outer circumferential surface of the armature 3 disposed opposing to the arc-shaped

magnet 1. The cogging torque is a substantial problems among the permanent magnet field small DC motors which are expected to be compact in size, yet required a high mechanical output with an accurate revolving performance. The motors are the object of the present invention.

5 Among the motors having an arc-shaped magnet, regardless whether it is a rare earth magnet or not, known technologies for reducing the cogging torque through a shape of the arc-shaped magnet include making a radius of the outer surface of the arc-shaped magnet to be different from that of the inner surface, or cutting edges at both ends in the circumferential direction of an arc-shaped magnet, thereby making a distribution of flux density in the air-gap closer to a sine curve (an example of the publication: Shogo Tanaka, "Application of Permanent Magnets for Small Motors", page 7 in the proceedings of the Symposium of Small Motor Technology, 1983). Japanese Utility Model Publication No. S44-4651 discloses that, in a permanent magnet field small DC motor, a cut provided in an arc-shaped magnet in the outer surface at both sides off of the center of the magnetic pole suppresses 10 reduction of effective flux at the center of magnetic pole, despite the reduction at the cut portion. Although there is no mention about the cogging torque in the Utility Model, there is an indication about a possibility that the cut provided in an arc-shaped magnet in the outer surface at both sides off of the center of the magnetic pole would reduce the cogging torque 15 in a permanent magnet field small DC motor, while controlling deterioration of the rotating torque.

20 A practical means for reducing the cogging torque in a permanent magnet field small DC motor, including the use of a thin arc-shaped rare earth magnet, is disclosed in Japanese Patent Laid-open Publication No.H11-18390. The disclosed means has a relevance with a method shown in FIGs. 2 (a), (b). In the drawings, a pair of arcuate permanent magnets 1, a soft-magnetic frame 2, an armature 3 including a brush-rectifier, a rotating shaft and a bearing, a hooking protrusion 21 for fitting and securing the pair of arc-shaped permanent magnets 1 to the soft-magnetic frame 2 are shown.

According to the disclosure, (1) the radius curvature of an arc-shaped magnet 1 at the outer surface is deviated from that of the inner surface so that the air-gap between the magnet and an armature core increases along with the increasing distance along the direction of circumference from the center of a magnetic pole towards both ends, namely, a structure of 5 so-called uneven air-gap, (2) the arc-shaped magnet having deviated radius curvature in the outer surface and inner surface is provided with a cut portion 11 so that there is an air-gap between the arc-shaped magnet and the soft-magnetic frame 2, and (3) the arc-shaped magnet 1 is slightly bent and fitted to be secured in the soft-magnetic frame 2 between the hooking protrusions 21. (An arc-shaped rare earth magnet with 12-nylon fabricated by 10 extrusion molding, ref. the Japanese Patent Laid-open Publication No. H6-236807, can be slightly bent.)

The direction of thrust in the arc-shaped rare earth magnet 1 coincides with that of extrusion in the extrusion molding, so the cross sectional shapes in the direction remain identical as shown in FIG. 2(b). Therefore, when an arc-shaped rare-earth magnet 1 is 15 secured in a soft-magnetic frame 2 with both ends thinned in the circumferential direction of the magnet 1, at which a vacant space is formed to the soft-magnetic frame 2, engaged by the hooking protrusions 21, the bent quantity at magnet 1 might increase depending on the variation in thickness value  $\pm 30$  m in the magnet 1. This can lead to a crack, tip-cut, etc. of the magnet 1 at the engagement portion, or even the magnet 1 might drop off the frame. 20 Thus, there is a possibility of serious hazards in the reliability of the permanent magnet field small DC motors in the above disclosure.

Next, a practical means for fixing a thin arc-shaped rare earth magnet to a soft-magnetic frame of permanent magnet field small DC motors is disclosed in Japanese Patent Laid-open Publication No. H11-18390, which is shown in FIGs. 3 (a), (b).

25 In the drawings, a pair of arc-shaped permanent magnets 1, a portion 11 of magnet for reducing cogging torque, an engagement portion 12 of the magnet, a soft-magnetic frame 2, an armature 3 including the brush-rectifier, shaft and bearing, and a hooking protrusion 21

for fixing and securing the pair of arcuate permanent magnets 1 in the soft-magnetic frame 2 are shown.

According to the disclosure, an arc-shaped rare earth magnet 1 has two or more different shapes in the cross section along the thrust direction; namely, a shape of the engagement portion 12 which is to be fitted-in between the hooking protrusions 21 of the soft-magnetic frame 2 and a shape of the portion 11 for reducing cogging torque. The means for reducing cogging torque disclosed in the above Laid-open patent remains identical to that taught in the Japanese Patent Laid-open Publication No. H10-201206, which is generally known means like deviating curvatures or cutting corners of a magnet. The problems of a crack, tip-cut, etc. of an arc-shaped rare earth magnet 1 at the engagement portion that might arise when it is fixed and secured in a soft-magnetic frame 2, or a drop-off of a magnet 1, which are relevant to the Japanese Patent Laid-open Publication No. H10-201206, can be significantly improved.

However, there is a difficulty in fabricating by, for example, extrusion molding an arc-shaped rare earth magnet of maximum thickness 1 mm or less that has two or more shapes in the cross section along the thrust direction. Providing the portion 11 for reducing the cogging torque will need a post machining process of cutting off both ends in the circumferential direction. Cutting a thin arc-shaped rare earth magnet 1 at a high precision level is quite difficult work, cracks, drop-offs readily arise to invite a poor manufacturing yield rate. Furthermore, particles of the raw material of rare earth magnet may increase the difficulty in finishing an arc-shaped rare earth magnet 1 to be ready for mounting in a soft-magnetic frame 2.

A rare earth magnet fabricated by compression molding from isotropic rare earth iron based melt-spun flakes mixed with a binder (e.g. an epoxy resin) for 1.5 - 3.0 weight%, in general, and heated for curing the binder, exhibits a density of 5.8 - 6.1 g/cm<sup>3</sup>. Whereas, the magnet fabricated by extrusion molding from the same rare earth iron based melt-spun flakes, which needs a binder (e.g. 12-nylon) for more than 5 weight%, exhibits a density of

5.7 g/cm<sup>3</sup> or less. Since the maximum energy product [BH] max of the magnet is dependent on the quantity of the filled rare earth iron based melt-spun flakes, or the magnet density, a compression molded rare earth magnet that can offer a higher [BH] max is more advantageous for providing a strong static magnet field in the air-gap between an armature  
5 and a magnet in the permanent magnet field small DC motors, as compared with the one fabricated by extrusion molding.

A first problem to be solved by the present invention is the problem described in Japanese Patent Laid-open Publication No. H6-236807, meaning that "since there is a substantially wide variation in the weighing at molding, it has been considered to be difficult  
10 to provide by compression molding thin arc-shaped magnets having a maximum thickness of 1 mm or less at a dimensional accuracy  $\pm 30 \mu\text{m}$ ". Even if the problem is solved, however, the mechanical strength of the compression molded rare earth magnet is low at the room temperature area, and brittle, because of a lower amount of resin contained therein. So, the arc-shaped rare earth magnets fabricated by compression molding are not suitable for fixing  
15 and securing in a soft-magnetic frame in accordance with the method taught in the Japanese Patent Laid-open Publication No. H10-201206 and the Japanese Patent Laid-open Publication No. H11-18390, meaning that attaching a magnet "at the engagement portion between the hooking protrusions of soft-magnetic frame with the magnet slightly bent".  
Namely, a second problem to be solved by the present invention is to contrive new means  
20 for securing an arc-shaped rare earth magnet in a soft-magnetic frame by appropriately taking the physical properties of the magnet into consideration. In addition, since "the [BH] max is higher than that of an arc-shaped rare earth magnet fabricated by extrusion molding", a third task to be attained in the present invention is to offer new additional means for controlling the distribution of flux density in the air-gap by a known means of providing the  
25 magnet with an appropriate shape for reducing the cogging torque.

#### DISCLOSURE OF THE INVENTION

A permanent magnet field small DC motor of the present invention has a stronger static magnet field in the air-gap between an armature and the magnet, by employing an arc-shaped rare earth magnet of 1 mm thick or less fabricated by compression molding. New control means for controlling distribution of flux density in the air-gap between an armature and the magnet as proposed by the present invention enhances the high precision revolving performance by further reducing cogging torque, in compact and high output motors.

#### BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1(a) shows a cross sectional view in a key portion of a motor in an exemplary embodiment of the present invention, FIG. 1(b) is a perspective view of a magnet used in the motor.

FIG. 2(a) shows a cross sectional view in a key portion of a conventional motor, FIG. 2(b) is a perspective view of a magnet used in the motor.

FIG. 3(a) shows a cross sectional view in a key portion of a conventional motor, FIG. 3(b) is a perspective view of a magnet used in the motor.

FIG. 4 is a characteristics chart showing demagnetization curves.

FIG. 5 is a characteristics chart showing the temperature dependence of breaking stress.

FIG. 6 is a characteristics chart showing the changes of cogging torque and back electromotive force (back emf) relative to the angle.

FIG. 7 is a characteristics chart showing the changes of cogging torque and back emf relative to demagnetization by heat.

#### BEST MODE FOR CARRYING OUT THE INVENTION

Referring to FIG. 1, an arc-shaped rare earth magnet 1 having a maximum thickness t of 1 mm or less is fabricated by compression molding from rare earth-iron based melt-spun flakes mixed with a binder, the outer surface 12 at both ends in the thrust direction of the

5 magnet is shaped in accordance with the inner surface of soft-magnetic frame 2, while a certain clearance is provided between the outer surface of the magnet 1 in the middle part in the thrust direction at both ends 11 in the circumferential direction and the soft-magnetic frame 2. The magnets are fixed and secured opposing to each other with an armature 3 disposed in between, to complete a finished permanent magnet field small DC motor.

10 An objective of forming the clearance is to provide the arc-shaped rare earth magnet 1 with a certain specific portion having no back yoke, in the middle part, in the thrust direction at both ends 11 in the circumferential direction. Thereby, providing the specific portion of the magnet with a demagnetization curve that is smaller than that at the center of magnetic pole in the circumferential direction. The clearance may be formed by modifying part of a shape in the soft-magnetic frame 2. However, it is preferably provided by: (1) Forming a plane surface at an angle  $\theta$  53 - 82° to the outer surface 12 in the middle part in the thrust direction of the arc-shaped rare earth magnet 1 at both ends in the circumferential direction. A clearance can be provided between both of the end-surfaces 11 and the soft-magnetic frame 2, totally through compression molding without requiring any post machining process; or

15 (2) Making the curvature of the outer surface, in the middle part, in the thrust direction at both ends in the circumferential direction of the arc-shaped rare earth magnet 1 different from that of the outer surface at both ends in the thrust direction. A clearance can be provided between both of the end-surfaces 11 and the soft-magnetic frame 2, totally through compression molding, without needing any post machining process. The arc-shaped rare earth magnet 1 may be attached to the soft-magnetic frame 2 by inserting it with the pair of outer surfaces 12 proceeding along the inner surface of the soft-magnetic frame 2, and fixing and securing it at both ends in the revolving direction using, for example, a spring 4 of U-shape. In this way, a compression-molded arc-shaped rare earth magnet 1, which is brittle and vulnerable to shearing force, yet can withstand relatively strong pressure, can be mounted in the soft-magnetic frame 2 easily and safely without cracks or dropping-off.

The above arc-shaped rare earth magnet 1 has been fabricated from a granular compound, particle diameter less than 250  $\mu\text{m}$  or less, of rare earth iron based melt-spun flakes mixed with an epoxy-resin binder for 1.5 - 3 weight%. The granular compound is compression molded into an arc-shaped molding cavity of compressed granular compound, and then it is cured of epoxy-resin binder. The rare earth iron based melt-spun flakes of a  $\text{RE}_2\text{TM}_{14}\text{B}$  (RE is Nd, Pr : TM are Fe, Co) phase, the grain size of 300 nm or less, exhibit an intrinsic coercivity  $H_{ci}$  8 - 10 kOe, remanence 7.4 - 8.6 kG. Or, it may contain isotropic rare-earth iron based melt-spun flakes of nano-composite structure having both the soft magnetic phase and the hard magnetic phase.

The rare earth iron based melt-spun flakes as referred to in the present invention are the ones as described, for example, by J. F. Herbest, in "Rare Earth-Iron-Boron Materials; A New Era in Permanent Magnets", Ann. Rev. Sci. Vol - 16. (1986). That is, molten alloy containing Nd : Fe : B in an approximate proportion 2 : 14 : 1 is rapidly-solidified, and precipitates the isotropic  $\text{Nd}_2\text{Fe}_{14}\text{B}$  phase by heat treatment. Any  $\text{Nd}_2\text{Fe}_{14}\text{B}$  phase would be available as long as the grain size of single magnet domains is approximately 300 nm or less. Or, a sort of nano-composite of soft magnet phase of, for example,  $\alpha\text{Fe}$ ,  $\text{Fe}_3\text{B}$  and hard magnet phase, such as  $\text{Nd}_2\text{Fe}_{14}\text{B}$ ,  $\text{Sm}_2\text{Fe}_{17}\text{N}_3$ , combined by a strong exchange interaction as a result of heat treatment applied on rare earth iron based melt-spun flakes can serve the purpose. The reason why the rare earth iron based melt-spun flakes are specifically nominated is that as a function of magnetization field they exhibit both a remanence  $B_r$  and a coercivity  $H_c$  both increasing simultaneously, and hence, exhibit a well-balanced demagnetization (B-H) curve even in an unsaturated magnetized state. For example, the permeance coefficient at the magnetic pole is different from that at both of the ends in the circumferential direction having no back yoke, and with respect to the magnetization of the arc-shaped rare earth magnet 1, the demagnetization (B-H) curves (remanence  $B_r$  and coercivity  $H_c$ ) at the magnetic pole become different from that at the ends 11 in the circumferential direction. This may be described in the following way, when a magnet is

fabricated from rare earth iron based melt-spun flakes, it exhibits different magnetic properties in the magnetic pole and both of the ends in the circumferential direction as if the magnet is a unitized permanent magnet formed of different magnets, despite the fact that it is formed of a same material.

5        The arc-shaped rare earth magnet 1 fixed along the inner surface of the soft-magnetic frame 2 is magnetized, and then it undergoes the initial demagnetization by heating. The portion of the magnetic pole which has a back yoke and shows a large demagnetization curve (large remanence value for Br and coercivity for Hcb), exhibits small demagnetization, while the outer portion in the middle part in the thrust direction of the magnet at both ends 11 in 10 the circumferential direction, which has no back yoke, exhibits large demagnetization at both ends. The distribution of flux density in the air-gap is improved much closer to a sine curve, and a rate of cogging torque reduction is greater than that of torque reduction. Thus, the distribution of flux density in the air-gap to the iron core of the armature 3 is put under control.

15        As described in the foregoing, the permanent magnet field small DC motors of the present invention comprise, not a conventional arc-shaped rare earth magnet of maximum thickness 1 mm or less fabricated by extrusion molding, but an arc-shaped rare earth magnet fabricated from rare earth iron based melt-spun flakes mixed with a binder by compression molding which has a higher [BH] max than that of the conventional magnet. The arc-shaped 20 rare earth magnet fabricated by compression molding containing more rare earth iron based melt-spun flakes exhibits an increase of both a remanence Br and a coercivity Hc simultaneously, as a function of magnetizing field, and hence, exhibits a well-balanced magnetization curve even in an unsaturated magnetized state. Under the same magnetization conditions, a stronger static magnet field is provided in the air-gap between the magnet and 25 the armature, so that a stronger output is obtained. Especially, with respect to the issue of cogging torque, which becomes significant along with the increasing output, the present invention proposes new improvement means of controlling the distribution of flux density

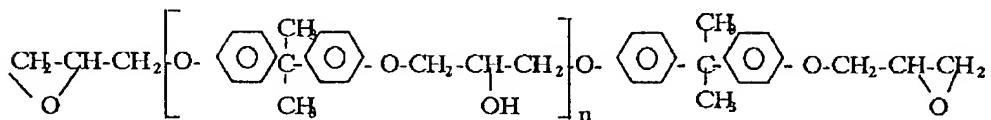
in the air-gap, which includes, (1) making a demagnetization curve in the middle part in the thrust direction of arc-shaped rare earth magnet at both ends in the circumferential direction small, making use of the reverse magnet field during magnetizing, (2) making use of the difference in demagnetization by heat, in addition to the conventionally known means for  
5 reducing the cogging torque by providing a magnet with a unique shape.

Now in the following, the present invention is described in further detail. The embodiments are only examples and not to be understood limitedly.

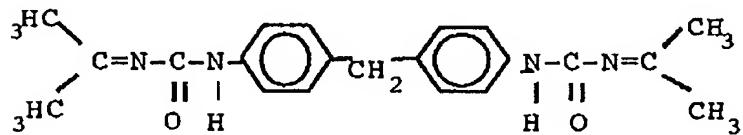
#### [Binder Composition]

An epoxy resin synthesized from bisphenol type epoxyoligomer (C1), weight average  
10 molecular weight Mw 1400, and blocked-isocyanate (C2) which is synthesized from 4-4'-diphenylmethan diisocyanate (1 mol) and methylethylketon-oxime (2 mol), are dissolved in acetone and the 50 wt. % aceton solution is used as binder. A ratio of the isocyanate -NCO group versus a sum of the alcoholic hydroxide group and the epoxy group in the molecular chain of epoxyoligomer is 0.8.

15 (C1)



(C2)



[Granular Compound]

Magnetic flakes used in this invention are a product from Magnequench International In, Co. (Trade Mark: MQP-B), which is a rare earth-iron based melt-spun flake with a thickness of 20 - 30  $\mu\text{m}$  and having an alloy composition of  $\text{Nd}_{12}\text{Fe}_{77}\text{Co}_5\text{B}_6$ , and an isotropic 5  $\text{Nd}_2\text{Fe}_{14}\text{B}$  phase with a grain size having a diameter of 20 - 50 nm.

Epoxy resin resolved in acetone (2.5 weight% in solid composition) and rare earth-iron based melt-spun flakes 97.5 weight% were wet-mixed using a sigma blade kneader. And then it was heated to 80 - 90°C to evaporate the acetone, and formed into a solid block at room temperature. The solid block was crushed using a cutter mill under room 10 temperature, and the crushed granule was classified in accordance with the particle diameter into granular compounds of 500, 350, 250, 212 and 150  $\mu\text{m}$ . Finally, it was mixed homogeneously with a V-blender at a temperature of 40°C or lower, after adding calcium stearate powder for 0.2 - 0.6 weight portion.

[Particle Diameter of Granular Compound and Dimensional Accuracy of Thin Arc-shaped 15 Green Compacts]

A granular compound was classified by particle diameter into classes smaller than 500, 350, 250, 212 and 150  $\mu\text{m}$ , respectively. The granular compound of each class was supplied to a powder compacting press (compression molding machine), measured in volume and compressed at 8 ton/cm<sup>2</sup> to form an arc-shaped green compact having thickness of 1 mm 20 or less. The compression molded arcuate item was cured at 160°C for 2 min. Thus, samples of so-called compression molded arc-shaped rare earth magnet were provided for 30 pcs. each class. Dimensions of the magnet are: Outer radius 3.65 mm; Inner radius 3.55 mm; Maximum thickness 0.90 mm; and Length in the thrust direction 15.5 mm.

The deviation of the maximum thickness 0.9 mm among the finished arc-shaped rare 25 earth magnets (n=30) in relation to the upper limit of particle diameter of granular compound used is represented in the following formula (regression coefficient 0.988).

$$A = 0.0003P^2 - 0.0718P + 24.745 \dots\dots\dots (1)$$

where A : represents range of thickness deviation( $\pm \mu\text{m}$ ), and  
P : the largest particle diameter  $\mu\text{m}$  of the granular compound.

As shown from the regression formula, when the granular compound having the  
5 particle diameter 250  $\mu\text{m}$  or less is used, the thickness deviation in the thin arc-shaped  
magnet of less than 1 mm thick can be suppressed to be less than  $\pm 30 \mu\text{m}$ , actually less than  
 $\pm 26 \mu\text{m}$ . Meanwhile, comparative samples for the same dimensions were also provided  
10 using pellets of 95 weight%, the same rare earth iron based melt-spun flakes mixed with 5  
weight% of 12-nylon at 260°C. The comparative samples were fabricated by the extrusion  
molding disclosed in the Japanese Patent Laid-open Publication No. H6-236807, with the  
temperature at the tip end of the molder dice set at 175°C, which is a temperature lower than  
melting point of 12-nylon. The thickness deviation among the comparative samples was  $\pm$   
30  $\mu\text{m}$ , at the portion of maximum thickness 0.9 mm.

It may be understood that the thin arc-shaped rare earth magnets having the same, or  
15 higher, dimensional accuracy as those fabricated by extrusion molding, can be fabricated  
from a granular compound by compression molding using a powder compacting press in  
accordance with the present invention. Which, according to the Patent Publication No. H6-  
236807, was described to be difficult.

#### [Magnetic Characteristics]

20 The granular compound having particle diameter of 250  $\mu\text{m}$  or less was compressed  
at 8 ton/cm<sup>2</sup> to form a round column 5 mm high with a diameter of 5 mm. The column was  
cured at 160°C for 2 min. to provide a column shaped rare earth magnet. The magnet was  
pulse-magnetized at 50 kOe in the direction of height. A demagnetization curve was  
25 measured using a vibrating sample magnetometer (VSM) at measuring magnetic field  $\pm 20$   
kOe.

Also, a demagnetization curve was measured with rare earth magnet fabricated by  
extrusion molding from pellets of rare earth iron based melt-spun flakes 95 weight% mixed

with 12-nylon 5 weight% at 260°C, molten and solidified. FIG. 4 compares the rare earth magnet fabricated by compression molding in accordance with the present invention and the comparative rare earth magnet fabricated by extrusion molding, with respect to demagnetization curve. Table 1 shows the magnetic characteristics derived from the demagnetization curve.

As indicated in FIG. 4 and Table 1, the magnet in the present invention exhibits a higher [BH] max. as compared with that of the comparative sample. Supposed reasons for the higher [BH] max. include, a higher packing density of rare earth iron based melt-spun flakes in the magnet of the present invention, whereas, the magnetic properties deteriorated in the comparative sample because the flakes were kneaded with a strong shearing force under a high temperature 260°C, which brought about oxidation of the crushed flakes.

Table 1

	Coercivity Hci kOe	Remanence $4\pi I_r$ kG	Maximum energy product [BH]max MGOe	Squareness Hk
Present Invention	9.53	6.87	9.55	2.59
Comparative Example	8.66	6.58	8.30	2.24

#### [Withstanding Stress and Fixing of Magnet to Soft-magnetic Frame]

A granular compound of particle diameter 250  $\mu\text{m}$  or less was delivered to a powder compacting press, measured in volume, and compressed at 8 ton/cm<sup>2</sup> to form an arc-shaped green compact of less than 1 mm thick. It was cured at 160°C for 2 min. to provide a so-called compressive-formed arc-shaped rare earth magnet. Dimensions of the magnet are: Outer radius 3.65 mm; Inner radius 3.55 mm; Maximum thickness 0.90 mm; and Distance in the thrust direction 15.5 mm. Also, a comparative sample of rare earth magnet having the

same shape was fabricated by extrusion molding from pellets of rare earth iron based melt-spun flakes 95 weight% and 5 weight% of 12-nylon kneaded at 260°C, molten and solidified.

5 FIG. 5 is a characteristics chart showing the temperature dependence of the withstanding stress of the above arc-shaped rare earth magnets. The withstanding stress refers to a load kgf given to the magnet at the portion of maximum thickness when it is broken, as shown in the drawing.

10 As it is clear from FIG. 5, the mechanical strength at room temperature of the compression-molded arc-shaped rare earth magnet in the present invention is as low as approximately 60 % of the extrusion-molded counterpart of the same dimensions, and brittle having the least bending property. Therefore, the magnet is not suitable for mounting in a soft-magnetic frame in accordance with a method described in the Japanese Patent Laid-open Publication No. H10-201206 or the Japanese Patent Laid-open Publication No. H11-18390, meaning, "fitting to be engaged between the hooking protrusions by slightly bending the arc-shaped rare earth magnet". If the magnet in the present invention is slightly bent and inserted 15 in a soft-magnetic frame, the magnet is liable to case breakage, or even falling-off, at the engaged portion. Therefore, the magnets of the present invention are not suitable for mounting in the frame at an agreeable yield rate in the industrial scale.

20 It is possible to glue a magnet of the present invention to a soft-magnetic frame. However, as described in the Japanese Patent Laid-open Publication No. H10-201216 and the Japanese Patent Laid-open Publication No. H11-18390, it is not an appropriate method to glue a magnet to a soft-magnetic frame for this type of permanent magnet field small DC 25 motors.

Magnets of the present invention can withstand a pressing stress in excess of 6 kgf at room temperature, as shown in FIG. 5. Comparing to the comparative sample, the 25 withstanding value is maintained until a temperature as high as approximately 120°C. So, it is preferred to fix a pair of the magnets 1 disposed along the inner surface of the soft-magnetic frame 2 with a U-shaped spring 4 which presses the magnet 1 at both ends in the

circumferential direction, as shown in FIG. 1. The strength of fixing the magnet 1 to the soft-magnetic frame 2 generally depends on the pressing force of a spring used. A pressing force of 0.5 kgf or less is enough for a generally considerable operating temperature range. So, a safety index relative to the allowable compression strength is more than ten times higher over the whole operating temperature range up to 120°C, which is the highest possible temperature with the permanent magnet field small DC motors, taking into consideration the allowable pressing stress and its temperature dependency. Thus, the magnet is mounted and secured with a sufficiently high reliability.

[Effect of the Portion of Magnet which Does Not Employ the Soft-magnetic Frame as Back Yoke]

FIG. 6 shows a relationship among the angle  $\theta$ , ref. FIG. 1, the rate of the cogging torque and the Back electromotive force (Back emf) with an arc-shaped rare earth magnet. The magnet is provided with a plane surface with an angle  $\theta$  to the curving outer surface of the compression mold, in the middle part (distance 12.5 mm) in the thrust direction of the magnet at both ends in the circumferential direction, for forming a clearance having no back yoke with respect to a soft-magnetic frame. The dimensions of the magnet are: Outer radius 3.65 mm; Inner radius 3.55 mm; Maximum thickness 0.90 mm; and Distance in the thrust direction 15.5 mm. Values at angle  $\theta$  of the plane surface are specified based on the values at an assumed 90° angle derived from the Japanese Patent Laid-open Publication No. H10-201206. In the permanent magnet field small DC motor used for measurement, the Back emf  $V$  is 0.218 mV/rpm, and the cogging torque  $C_t$  was 1.15 g-cm, at  $\theta = 90^\circ$ .

As seen in the drawing, the Back emf  $V$  decreases linearly relative to the angle  $\theta$  as derived from the regression formula, but the decrease is as small as 5 % in a range of  $\theta$  from 90° to 53°. The cogging torque  $C_t$ , however, shows a significant change in a second-order function relative to the angle  $\theta$  and the change reaches the highest at approximately  $\theta = 65^\circ$ . The cogging torque is reduced by almost 70 % at that highest point. Even in a range between 82° to 53°, it is reduced by more than 40 % from the value at 90°.

The above-described advantage has been brought about by the thin arcuate rare earth magnet having at both ends in the circumferential direction, a region having no back yoke and being fabricated from rare earth iron based melt-spun flakes, which exhibits both a remanence  $B_r$  as a function of magnetizing field and a coercivity  $H_{cB}$  both increasing simultaneously and hence, exhibits a well-balanced magnetization curve even in an unsaturated magnetized state. Thus, the permanent magnet field exhibits a magnetic performance as if different magnets having different respective properties unified into one magnet.

The arc-shaped rare earth magnet as disclosed in the Japanese Patent Laid-open Publication No. H11-18390, having an engagement portion to be engaged with a hooking protrusion of a soft-magnetic frame and a portion for reducing cogging torque, namely, a rare earth magnet which has two or more shapes in the cross section along the so-called thrust direction, cannot be fabricated by extrusion molding as taught in the Japanese Patent Laid-open Publication No. H6-236807. However, by the compression molding of the present invention, the arc-shaped rare earth magnet with the portion having no back yoke of the soft-magnetic frame can be provided through either (1) providing a plane surface at an angle  $\theta$   $53^\circ - 82^\circ$  to the curving outer surface of the compression mold, in the middle part in the thrust direction of the arc-shaped rare earth magnet at both ends in the circumferential direction, or (2) making a curvature of the outer surface in the middle part in the thrust direction of the magnet different from that of the outer surface at both ends in the thrust direction. In either of the cases, an arc-shaped rare earth magnet can be formed to a finished magnet totally by a powder compacting press (compression molding process), without using any post machining process.

#### [Effect of Heat Demagnetization of Magnet in No Back Yoke Portion]

An unsaturated magnetization was applied on an arc-shaped rare earth magnet provided with a plane surface at an angle  $\theta$   $62^\circ$  to the curving outer surface of the compression mold, in the middle part in the thrust direction (distance 12.5 mm) at both ends

in the circumferential direction for forming a certain clearance having no back yoke with respect to a soft-magnetic frame, in 4 stages with a capacitance  $2000 \mu\text{F}$ , at  $1500 - 2400 \text{ V}$ . FIG. 7 is a characteristics chart showing a change in the cogging torque and the Back emf, before and after a demagnetization conducted by exposing to a temperature  $140^\circ\text{C}$  for 5 min.

5 The dimensions of the magnet are: Outer radius 3.65 mm; Inner radius 3.55 mm; Maximum thickness 0.90 mm; and Distance in the thrust direction 15.5 mm. The values are those which have been normalized to the cogging torque and the Back emf of the magnet magnetized with the maximum magnetization field, at  $2000 \mu\text{F}$ ,  $2400 \text{ V}$ , before the demagnetization by heat. In the permanent magnet field small DC motor measured here, the

10 reference Back emf V is  $0.214 \text{ mV/rpm}$ , and the cogging torque Ct is  $0.46 \text{ g-cm}$ .

As shown in the chart, when a permanent magnet field small DC motor of the present invention is demagnetized by heat, the reduction of Back emf V generally remains at 0.5 % or less. However, the cogging torque is further reduced for approximately 10 %. When an arc-shaped rare earth magnet mounted and fixed along the inner surface of a soft-magnetic frame is magnetized and then given with an initial demagnetization by heat, the portion of a center of a magnetic pole having a back yoke exhibits a small demagnetization, while the outer surface in the middle part in the thrust direction of the magnet at both ends in the circumferential direction, which ends having no back yoke, exhibit a large demagnetization, even when the magnet has a large demagnetization (B-H) curve (large remanence  $\text{Br}$  and coercivity  $\text{HcB}$ ). As a result, the distribution of flux density in the air-gap is further improved to be closer to a sine curve and the larger cogging torque reduction is obtained relative to the reduction of Back emf caused by the demagnetization.

#### INDUSTRIAL APPLICABILITY

25 A permanent magnet field small DC motor of the present invention comprises an arc-shaped rare earth magnet of maximum thickness 1 mm, fabricated by compression forming from rare earth iron based melt-spun flakes mixed with a binder, the magnet being provided

with a certain portion having no back yoke at both ends in the circumferential direction for forming a clearance with respect to a soft-magnetic frame when it is fixed therein with a pressing force. The arc-shaped rare earth magnet containing more rare earth iron based melt-spun flakes exhibits both a remanence  $B_r$  as a function of a magnetizing field and a coercivity  $H_cB$  both increasing simultaneously and hence, exhibits a well-balanced magnetization curve even in an unsaturated magnetized state. Under the same magnetization conditions, the magnet provides a stronger static magnetic field in the air-gap between the magnet and the armature, hence, a higher output becomes available. The problem of cogging torque, among others, which becomes significant along with the increasing output, is improved by new means proposed in the present invention of controlling the distribution of magnetic flux density in the air-gap, in addition to improvement by well known means of controlling a specific shape. The new means in the present invention includes (1) making a demagnetization curve small in the middle part of the magnet in the thrust direction at the end part in the circumferential direction, making use of the reverse magnet field at magnetization, and (2) making use of a difference caused by the heat demagnetization. Thus, a compact high output small DC-motor with a highly accurate revolving performance can be implemented in accordance with the present invention.

What is claimed is:

1. (amendment) A permanent magnet field small DC motor comprising: an arc-shaped permanent magnet fixed in a soft-magnetic frame, wherein

    said magnet is provided with an outer surface at both ends in a thrust direction that fits along an inner surface of said soft-magnetic frame, and a certain region in a middle part in the thrust direction of said magnet at both ends in the circumferential direction where said soft-magnetic frame does not function as a back yoke.

2. (amendment) The permanent magnet field small DC motor of claim 1, wherein a pair of arc-shaped permanent magnets opposing to each other are disposed in the soft-magnetic frame with the outer surfaces at both ends in the thrust direction fitting along the inner surface of the soft-magnetic frame, and fixed at both ends in the circumferential direction using a spring.

3. (amendment) The permanent magnet field small DC motor of claim 2, wherein the arc-shaped permanent magnets are compression molded from rare earth iron based melt-spun flakes and a binder.

4. (amendment) The permanent magnet field small DC motor of claim 2, wherein a maximum thickness of the arc-shaped magnets are 1 mm or less.

5. (amendment) The permanent magnet field small DC motor of claim 1, wherein a certain air-gap is provided between the outer surface of the arc-shaped permanent magnet in the middle part in the thrust direction at both ends in the circumferential direction and the soft-magnetic frame.

6. (amendment) The permanent magnet field small DC motor of claim 3, wherein a curvature of the outer surfaces of the arc-shaped rare earth magnets in the middle part in the thrust direction is made to be different from that of an outer surface at both ends in a thrust direction in a compression mold so that the soft-magnetic frame does not function as a back yoke at the region of

the outer surface in the middle part in the thrust direction at both ends in the circumferential direction.

7. (amendment) The permanent magnet field small DC motor of claim 1, wherein a pair of arc-shaped rare earth magnets opposing to each other fixed along the inner surface of said soft-magnetic frame exhibits different demagnetization curves at least by unsaturated magnetization.

8. (amendment) The permanent magnet field small DC motor of claim 5, wherein a distribution of flux density in the gap with the armature iron core is controlled by once magnetizing a pair of arc-shaped rare earth magnets opposing to each other fixed along the inner surface of soft-magnetic frame and then providing an initial demagnetization by heat so that a rate of demagnetization increases along with a distance from a center of a magnetic pole towards the ends in the circumferential direction, eventually making the demagnetization rate reaching the greatest at the air-gap formed between the middle part of the outer surface in the thrust direction at both ends in the circumferential direction and the soft-magnetic frame.

9. (amendment) An optical pickup device comprising the permanent magnetic field small DC motor of claim 1.

**A B S T R A C T**

A permanent magnet field small DC motor comprising an arc-shaped rare earth  
5 magnet of maximum thickness 1mm or less fabricated by compression molding from rare  
earth iron based melt-spun flakes and a binder. The magnet is provided with a certain  
specific portion at both ends in the circumferential direction, which has no back yoke when  
the magnet is press-fit in a soft-magnetic frame. The arc-shaped rare earth magnet fabricated  
10 by compression molding from a material containing more rare earth iron based melt-spun  
flakes exhibits simultaneous increase of both a remanence  $B_r$  as a function of magnetizing  
field and a coercivity  $H_c$  and hence, exhibits a well-balanced demagnetization (B-H) curve  
even in an unsaturated magnetized state.

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FIG. 1

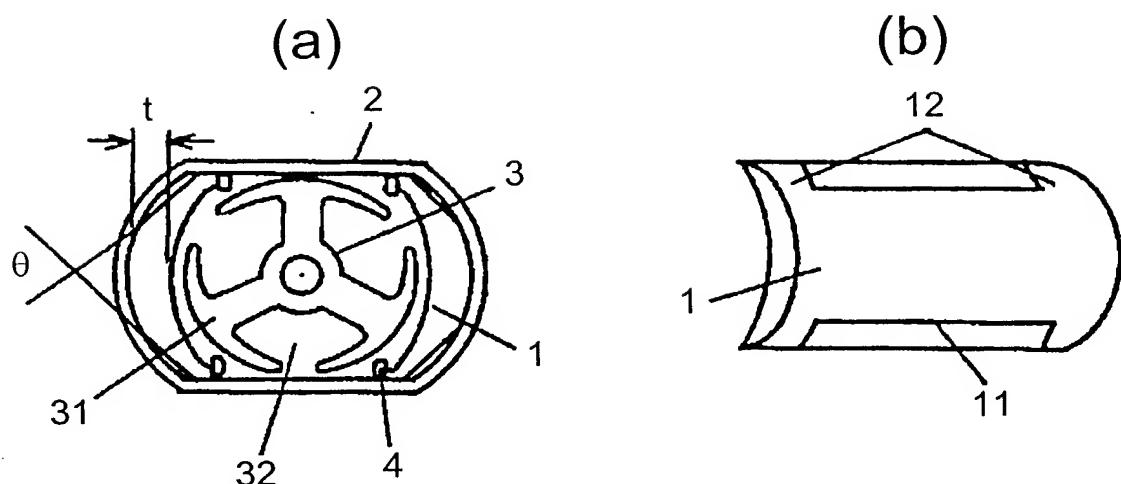
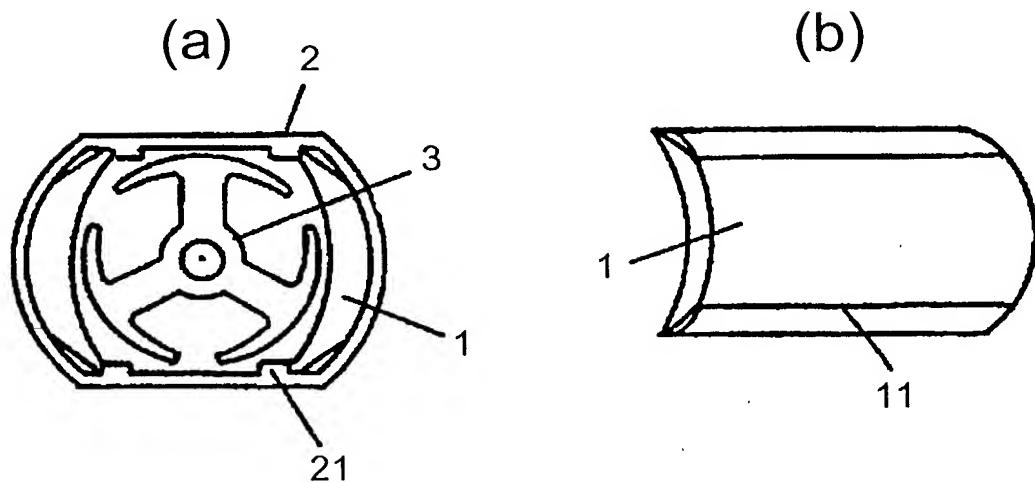


FIG. 2



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FIG. 3

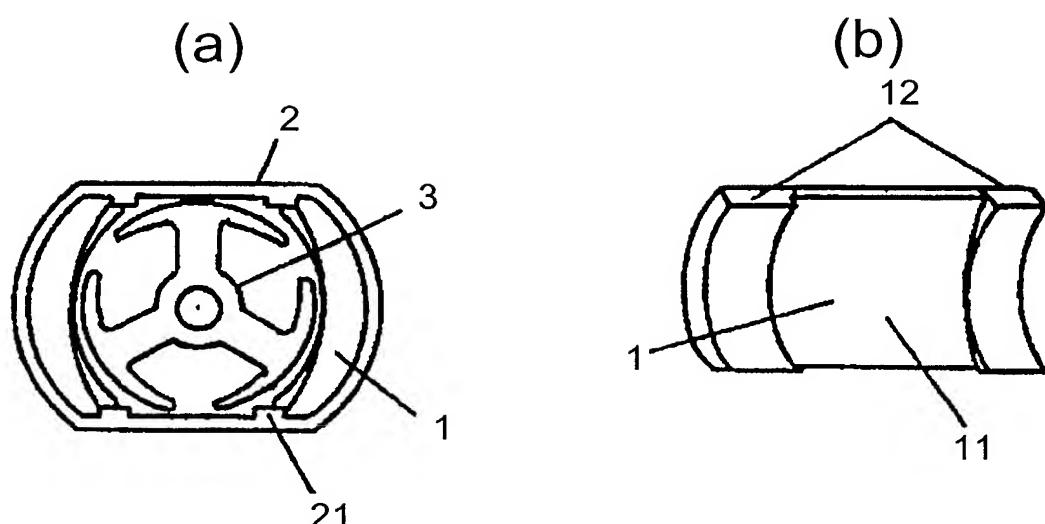
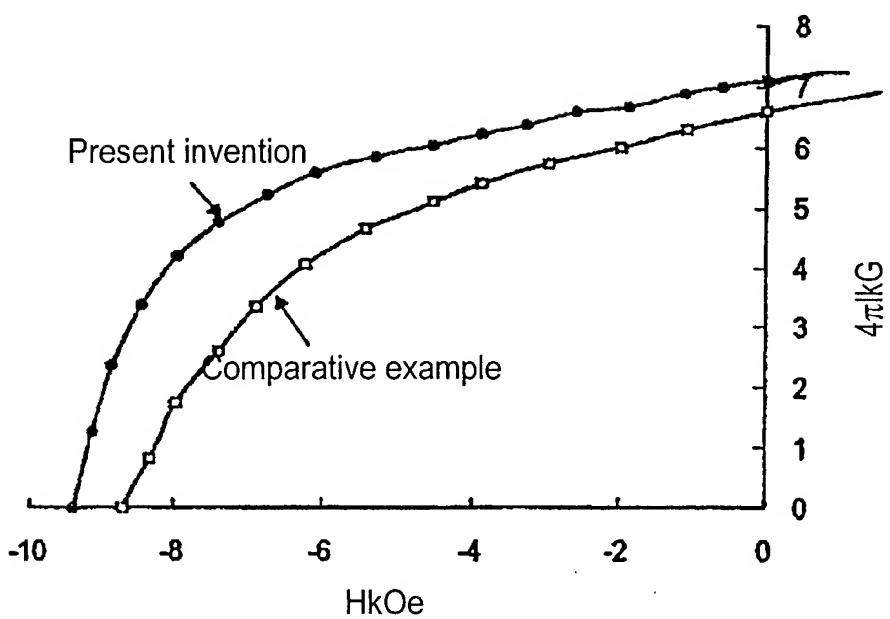


FIG. 4



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FIG. 5

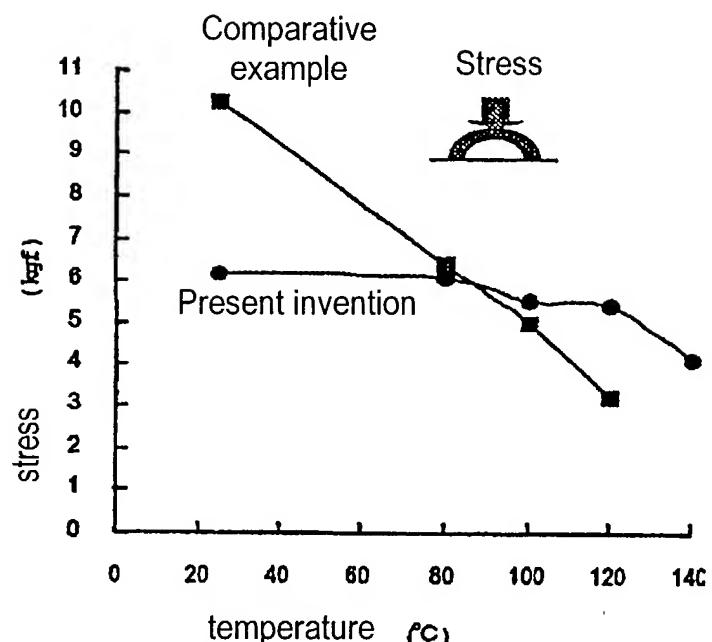
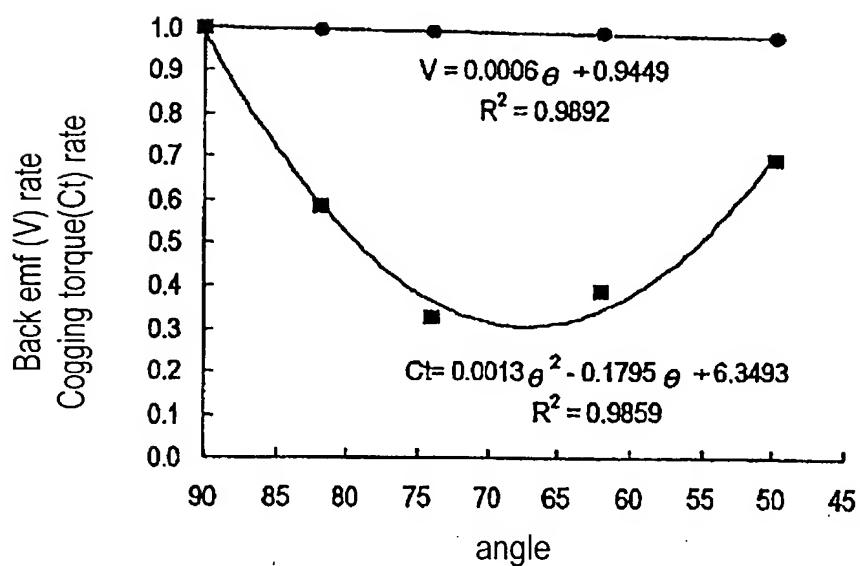


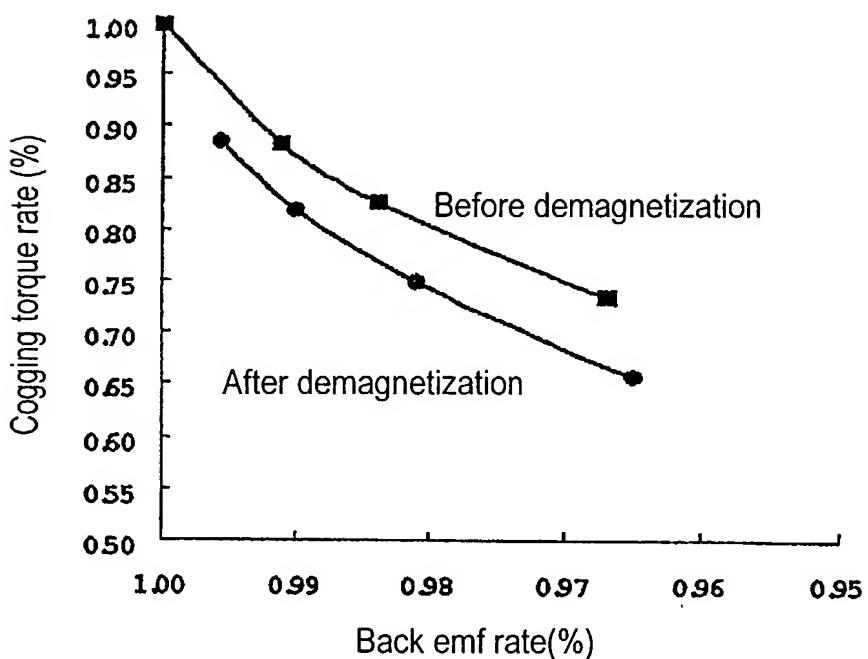
FIG. 6



107069585

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FIG. 7



JUN-26-'02 17:12 TO:WENDEROTH

FROM: マツシタギ ジュウジ ヨウホウ

R:896 P:02/06

Rev. 3-21-01

Effective March 1998

#6

## DECLARATION AND POWER OF ATTORNEY FOR U.S. PATENT APPLICATION

() Original ( ) Supplemental ( ) Substitute (X) PCT ( ) DESIGN

As a below named inventor, I hereby declare that: my residence, post office address and citizenship are as stated below next to my name; that I verily believe that I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural inventors are named below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

Title: PERMANENT MAGNET FIELD SMALL DC MOTOR

of which is described and claimed in:

( ) the attached specification, or  
 (X) the specification in application Serial No. 10/069,585, filed February 27, 2002, and with amendments through the Preliminary Amendment filed February 27, 2002  
 (X) the specification in International Application No. PCT/JP00/05733, filed August 25, 2000, and as amended on (if applicable).

I hereby state that I have reviewed and understand the content of the above-identified specification, including the claims, as amended by any amendment(s) referred to above.

I acknowledge my duty to disclose to the Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, Code of Federal Regulations, §1.56.

I hereby claim priority benefits under Title 35, United States Code, §119 (and §172 if this application is for a Design) of any application(s) for patent or inventor's certificate listed below and have also identified below any application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed:

COUNTRY	APPLICATION NO.	DATE OF FILING	PRIORITY CLAIMED
Japan	11-241107	August 27, 1999	YES

I hereby claim the benefit under Title 35, United States Code §120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code §112, I acknowledge the duty to disclose information material to patentability as defined in Title 37, Code of Federal Regulations, §1.56 which occurred between the filing date of the prior application and the national or PCT international filing date of this application:

APPLICATION SERIAL NO.	U.S. FILING DATE	STATUS: PATENTED, PENDING, ABANDONED

And I hereby appoint Michael R. Davis, Reg. No. 25,134; Matthew M. Jacob, Reg. No. 25,154; Warren M. Cheek, Jr., Reg. No. 33,367; Nils Pedersen, Reg. No. 33,145; Charles R. Watts, Reg. No. 33,142; and Michael S. Huppert, Reg. No. 40,268, who together constitute the firm of WENDEROTH, LIND & PONACK, L.L.P., as well as any other attorneys and agents associated with Customer No. 000513, to prosecute this application and to transact all business in the U.S. Patent and Trademark Office connected therewith.

I hereby authorize the U.S. attorneys and agents named herein to accept and follow instructions from Matsushita Electric Industrial Co., Ltd. as to any action to be taken in the U.S. Patent and Trademark Office regarding this application without direct communication between the U.S. attorneys and myself. In the event of a change in the persons from whom instructions may be taken, the U.S. attorneys named herein will be so notified by me.

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P.04/06

I further declare that all statements made herein of my own knowledge are true, and that all statements on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

1st Inventor Fumitoshi Yamashita Date June 24, 2002  
YAMASHITA Fumitoshi

2nd Inventor Sasaki Yuichiro Date June 24, 2002  
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3rd Inventor \_\_\_\_\_ Date \_\_\_\_\_

4th Inventor \_\_\_\_\_ Date \_\_\_\_\_

5th Inventor \_\_\_\_\_ Date \_\_\_\_\_

6th Inventor \_\_\_\_\_ Date \_\_\_\_\_

The above application may be more particularly identified as follows:

U.S. Application Serial No. 10/069,585 Filing Date February 27, 2002

Applicant Reference Number P23728-01(I.S. Machizuki) Atty Docket No. 2002\_0214A

Title of Invention PERMANENT MAGNET FIELD SMALL DC MOTOR